



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE-350DAMPER
Job Sheet 179238



Part No: RBE-350DAMPER

Job Qty: 5 ea

Part Name: Damper Spanner Wrench



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 6/14/18

Job Tracking No:

Due Date: 8/6/18

Created By: Logan David

Type: Stock

Description:

Note: DWG RBE-350DAMPER REV:1 IPP REV:A 18.01.16 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	8/6/18	8/6/18	0.00	0.00	Start Up Large Fab-3		ER
95	Large Fab	5 pcs	8/6/18	8/6/18	0.00	1.25	Large Fab 3		ER
100	QC	5 pcs	8/6/18	8/6/18	0.00	0.00	QC5		DS
110	QC	5 pcs	8/6/18	8/6/18	0.00	0.00	QC9		DS
115	HandFinish	5 pcs	8/6/18	8/6/18	0.00	0.00	HandFinish7		DS
120	Outsource	5 pcs	8/6/18	8/6/18			GRO002-SEP 14 2018		DS
125	Packaging	5 pcs	8/6/18	8/6/18	0.00	0.00	Packaging2		DS
126	QC	5 pcs	8/6/18	8/6/18	0.00	0.00	QC6		DS
130	Packaging	5 pcs	8/6/18	8/6/18	0.00	0.00	Packaging3-2		DS
500	QC21-FG	5 Ea	8/6/18	8/6/18	0.00	0.00	QC21		DS

Part Op 95 - WELD AS PER DWG

Descriptions: 120 - Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required
130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE-350DAMPER-03	Adjustable spanner	5 Ea (1 ea)	90-Start up Operation	102443
RBE-350DAMPER-05	Pin	10 Ea (2 ea)	90-Start up Operation	102278

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBE-350DAMPER-03	5	0	0
	RBE-350DAMPER-05	10	0	0

Part Specifications



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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

be found.

Plex 6/14/18 3:49 PM dart.logan.david

Container No: S107757



Part: RBE-350DAMPER

Job No: 179238

Serial No/Batch: S107757

Revision: 1

Inspector:

Exp Date:

Instructions:

DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
Inspection Dwg:	Rev:		Page 1 of 1

INSPECTION SHEET

[illegible]

Measured by:		Checked by:		QC Inspector:	
Date:		Date:		Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

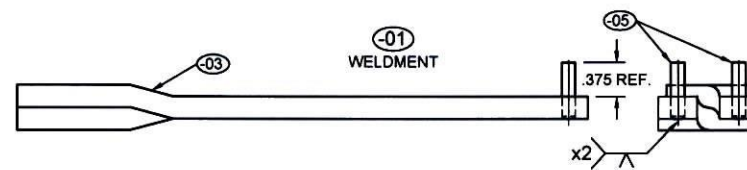
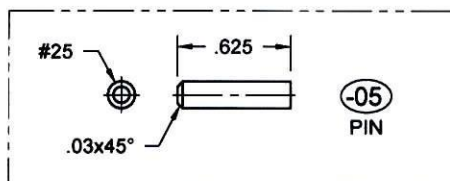
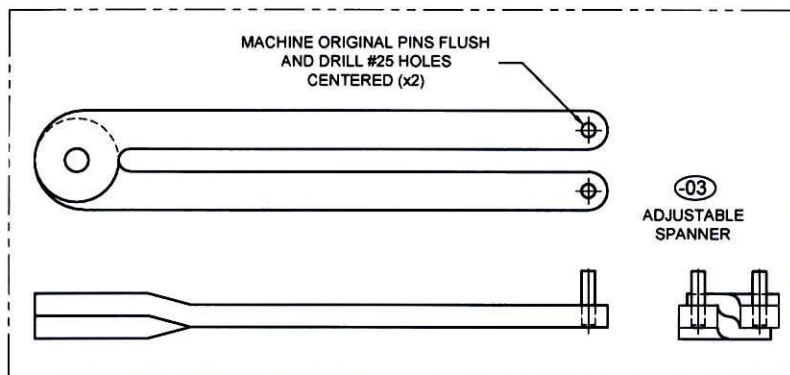
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	DESIGNED PER HELI PRODUCTS TOOLS.	9/9/09	WP DW



FUNCTION: USED TO REMOVE DAMPER CAP

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS
			-01	1	WELDMENT		
1	MACH	-03			ADJUSTABLE SPANNER	FORGED STEEL	MCMaster-CARR #5481A1
2	MACH	-05			PIN	DRILL ROD	#25 MCMaster-CARR #3009A237
ASSY	-01						

RED BARN MACHINE	
TITLE DAMPER SPANNER WRENCH	
DWG NO. RBE-350DAMPER	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	
FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 9-9-09
SHEET 1 of 1	

DRAWN BY: PERRITT
APPROVED: *D. M. Pitt*
HEAT TREAT: BLACK OXIDE
FINISH SPEC: USED ON MODEL
EUROCOPTER AS350/355



METAL TECHNOLOGY INC.

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Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Att

Shipment No: 24035
Shipment Date: 14-Sep-2018
Ship Via: Pick Up
Order Number: 3026
Order Date: 09/13/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO041012
Terms: ?

----- Quantity -----								Job
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Number</u>
1	1	1	0	0	LOT	BLACK OXIDE TREATMENT BLACK OXIDE		3026-01

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.